

Date: Friday, 1/25/2008 10:54:10 AM
 User: Kiifi Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	206L AFT X-TUBE		
Job Number	36979		Part Number	D206667203		
Estimate Number	10973		Drawing Number	D206-667-243 REV B		
P.O. Number			Project Number	N/A		
This Issue	1/25/2008	S.O. No.		Drawing Revision		
Prsht Rev.	NC		Material			
First Issue	/ /	Type	LANDING GEAR	Due Date	3/10/2008	Qty: 1 Um: Each
Previous Run	36382					
Written By	<u>PAJ 080125</u>					
Checked & Approved By						
Comment	Est Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL Photocopy bluefile and create labels as per PPP D206-667-203 CHG002	<u>08/04/01 08.02.28</u>
2.0	D6004115	Crosstube material	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part number Description Batch 1 D6004-115 Crosstube <u>334685</u> Check OD = 2.500"; ID = 1.800"	<u>BG 08-02-27</u>
3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE	
		Comment: MORI SEIKI CNC LATHE LARGE 1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA089 2-Turn first side as per Folio FA089 3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.	<u>BG 08-03-02</u>
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	<u>BG 08-03-02</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:54:10 AM
User: Kim Johnston

Process Sheet

Custodian: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 36979

Part Number: D206667203

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 MORI SEIKI



MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA089

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243
Inside of Cuff(Donot engrave on outside of tube)

SG 08-03-02 (C)

6.0 QC1



INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SG 08-03-02 (C)

7.0 QC8



SECOND CHECK



Comment: SECOND CHECK

SG 08/03/03 (C)

8.0 LANDING GEAR 1



LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

A W M 8-3-4

1-Polish entire outside surface of crosstube

9.0 QC5



INSPECT WORK TO CURRENT STEP

DP 8-3-4



Comment: INSPECT WORK TO CURRENT STEP

10.0 HAND FINISHING1



HAND FINISHING RESOURCE #1

A W M 8-3-4



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

11.0 BENDING



BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT

EL 8-3-24

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 36979

Part Number: D206667203

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



JAN 03 2008



Comment: DIMENSIONAL CHECK OF X-TUBES

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

AM 8-3-25

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



AM 8-3-25



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



8/3/08



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16.0

QC5

INSPECT WORK TO CURRENT STEP



8/3/08



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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User: Kim Johnston

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Drawing Name: 206L AFT X-TUBE

Job Number: 36979

Part Number: D206667203

Job Number:



Seq. #: Machine Or Operation:

Description :

17.0 OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 6020

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C 08/03/31 ①

18.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

P 08/03/20 ①

19.0 QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

M 08 03 29 ①

20.0 SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes

2-Prime inside and outside crosstube as per QSI 005 4.2

3-Paint outside crosstube with White Imron as per QSI 005 4.2

ZT 08 03 28

21.0 QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

M 08 03 29 ①

22.0 D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch
2 D2873-045 Nut Plate

340771/393411

ZT 08 03 28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 36979

Part Number: D206667203

Job Number:



Seq. #: Machine Or Operation:

Description :

23.0 D2873043 Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate

36064

2T 08-03-28

24.0 MS20601AD4W10 RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet

105057

2T 08-03-28

25.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

2T 08-03-28

26.0 D2856400 Abrasion Strip



Comment: Qty.: 1.3525 f(s)/Unit Total : 1.3525 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 7.73") Abrasion Strip

35900

M 08 03 29

27.0 D28921 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2892-1 Support

34063

M 08 03 29

28.0 MS2192022 Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22 Clamp

106601

M 08 03 29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Friday, 1/25/2008 10:54:11 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 36979

Part Number: D206667203

Job Number:



Seq. #: Machine Or Operation:

Description :

29.0 LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8580. Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

W
08/03/19(1)

30.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/31 (X)

31.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0 AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M104679

SQ

33.0 MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M106277

SQ

34.0 AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part number

10 AN5-10A

Description Batch

Bolt M107013

SQ

35.0 AN532A

Bolt



M106242

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part number

10 AN5-10A

Description Batch

8/3/31

SQ

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 36979

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 AN5-32A Bolt _____

36.0 AN960JD516 Washer _____



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part number Description Batch

18 AN960JD516 Washer M106654

37.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

38.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location: C

PPP Rev: _____

39.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-01

W

D206 667 203 B36979

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36979
Description: Crosstube Assembly	Part Number:	D206-667-243
Inspection Dwg: D206-667-243 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

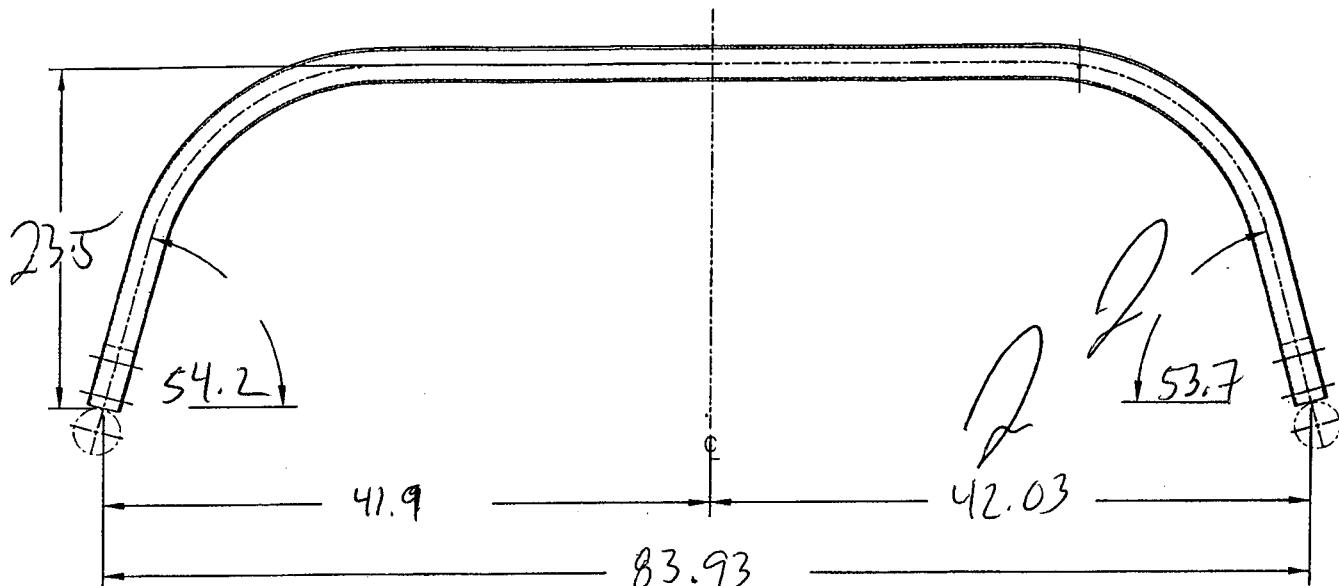
Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.492	✓		
	2.018	+0.005/-0.000	2.022	✓		
	2.079	+0.005/-0.000	2.082	✓		
	2.145	+0.005/-0.000	2.148	✓		
	2.209	+0.005/-0.000	2.213	✓		
	2.287	+0.005/-0.000	2.290	✓		
	2.363	+0.005/-0.000	2.364	✓		
	2.433	+0.005/-0.000	2.436	✓		
	0.200	+/-0.010	.200	—		
	0.500 x 30°	+/-0.010	.500	✓		
	R0.063	+/-0.010	.063	✓		
	R0.500	+/-0.010	.500	✓		
	4.438	+/-0.030	4.438	✓		
	104.91	+/-0.020	104.91	✓		
	2.490	+0.005/-0.000	2.492	✓		
SIDE B	2.018	+0.005/-0.000	2.022	✓		
	2.079	+0.005/-0.000	2.083	✓		
	2.145	+0.005/-0.000	2.148	✓		
	2.209	+0.005/-0.000	2.213	✓		
	2.287	+0.005/-0.000	2.290	✓		
	2.363	+0.005/-0.000	2.365	✓		
	2.433	+0.005/-0.000	2.436	✓		
	0.200	+/-0.010	.200	✓		
	0.500 x 30°	+/-0.010	.500	✓		
	R0.063	+/-0.010	.063	✓		
	R0.500	+/-0.010	.500	✓		
	4.438	+/-0.030	4.438	✓		
	104.91	+/-0.020	104.91	✓		
	2.490	+0.005/-0.000	2.492	✓		
	2.018	+0.005/-0.000	2.022	✓		

Measured by:	<i>SC</i>	Audited by:	<i>JNL</i>	Prototype Approval:	N/A
Date:	08.03.02	Date:	08/03/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue (P/O D206-667-203)	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	36979
Description: Crosstube High Aft (206L)	Part Number:	D206-667-203
Inspection Dwg: D206-667-243 Rev: B		Page 1 of 1

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments

QC15 Inspection	<i>J</i>
Date	<i>0803-24</i>

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[initials]</i>	<i>[Signature]</i>

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H DS	APPROVED H DS	DRAWING NO. D206-667-243	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED 05.07.26 - H

UNDER REVIEW**06.07.04 RT**

12 DRAW DRAFT F

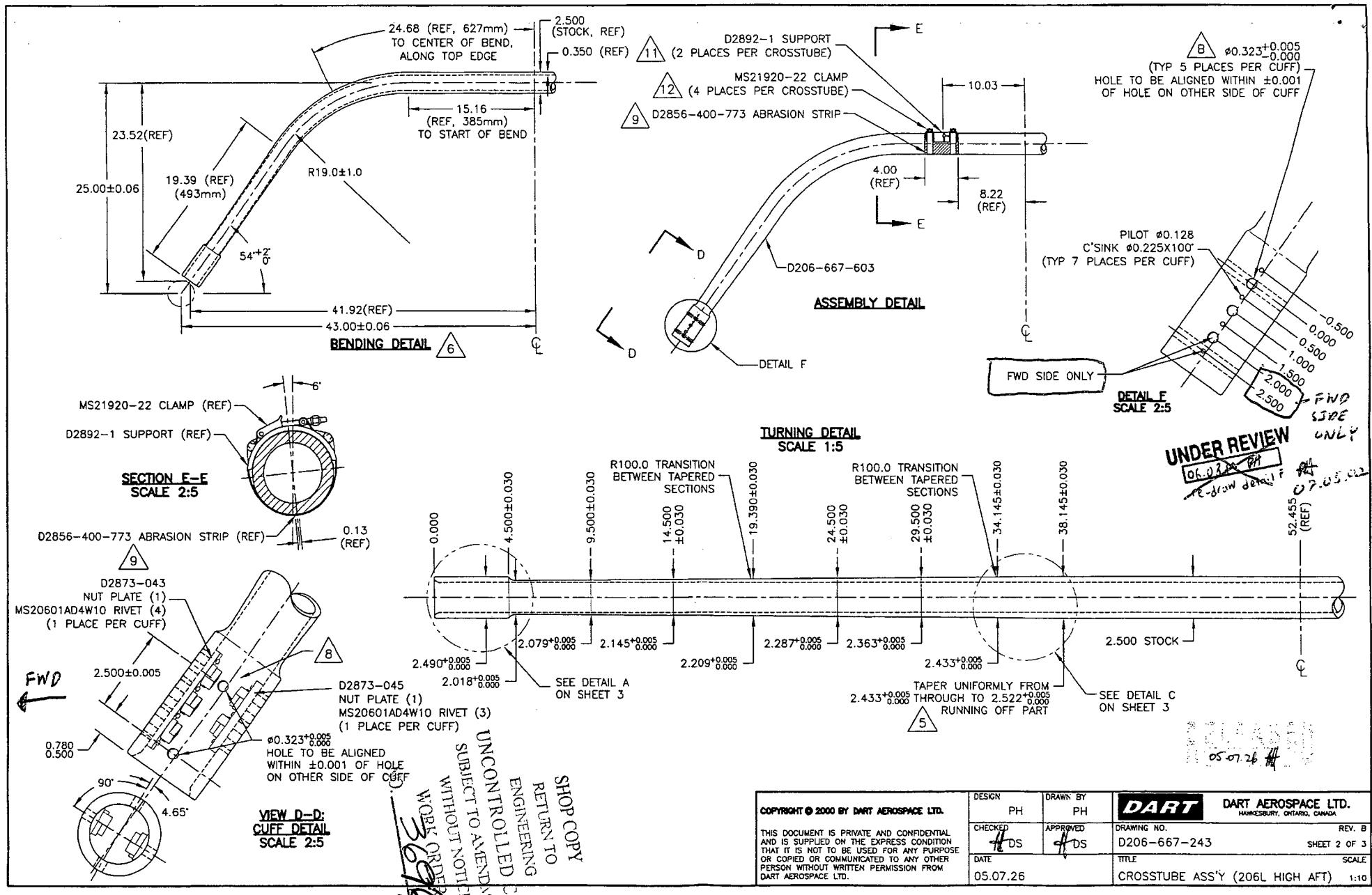
PH
07.05.04

Qty	Part Number	Description
X	D206-667-243	CROSSTUBE ASSEMBLY
1	D6004-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2892-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-22	CLAMP

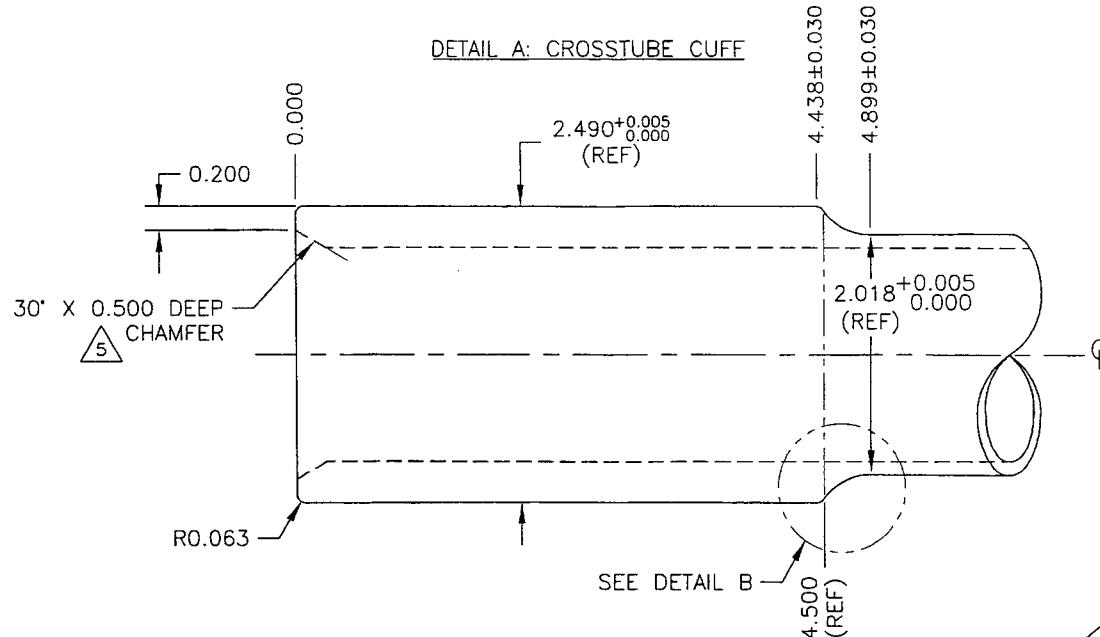
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36979

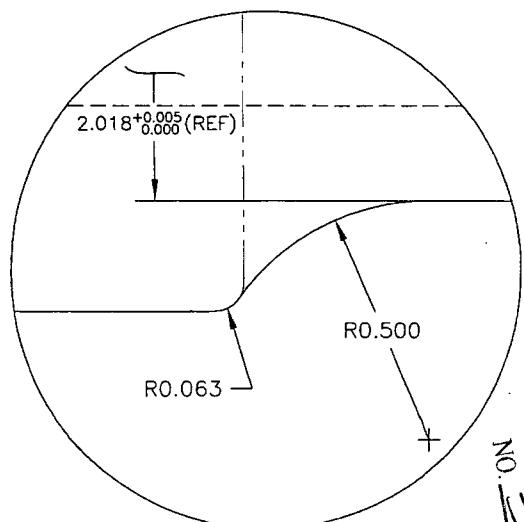


DETAIL A: CROSSTUBE CUFF



UNDER REVIEW
06.07.26 PM
ZG - draw detail
PH 07.05.02

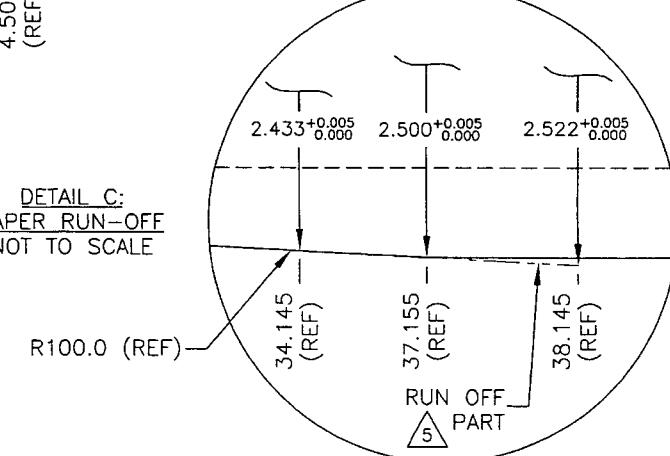
DETAIL B: CUFF TRANSITION
SCALE 4:1



NO. 36979

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

DETAIL C: TAPER RUN-OFF
NOT TO SCALE



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DART AEROSPACE LTD.

DESIGN
PH
CHECKED
HDS

DRAWN BY
PH
APPROVED
HDS

DART
DRAWING NO.
D206-667-243

DART AEROSPACE LTD.
MARKSBURY, ONTARIO, CANADA
REV. B
SHEET 3 OF 3
TITLE
CROSSTUBE ASS'Y (206L HIGH AFT)
SCALE
1:1

ACUREN

LIQUID PENETRANT TEST REPORT

P - 1262 1

CLIENT	DART AEROSPACE	DATE	MAR 28 2008	PAGE	1	OF 1
ATTENTION	LINDA LACELLE	ACUREN JOB NO.	188 08 1262	TIME	AM <input type="checkbox"/>	PM <input type="checkbox"/>
ADDRESS	1270 ABERDEEN ST HAWKESBURY, ONT.	PO/WO NO.	<i>6020 M.M.</i>	WORK LOCATION	HAWKESBURY	
PROJECT	212/205 HIGH AFT X TUBE, 206L AFT X TUBES	ACCEPTANCE STD.	ASTM 1417/QSI-038	REV./DATE	2005	
ITEM(S) EXAMINED	JOB #S 212/205-37055, 37057, 206L-36977 (36979)					

JOB DESCRIPTION	PROCEDURE NO.	LT-0002	REV./DATE	TECHNIQUE NO.	LT-TECH2	REV./DATE
PART NO. D212664201/D206667203			MATERIAL	ALODINED ALUM.		THICKNESS
SCOPE WET FLOUORESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% EXTERNAL SURFACE						

TEST DETAILS						
METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED	
FAMILY BRAND	MAGNAFLUX			BLACK LGHT8171	<input type="checkbox"/> OUTPUT > 1000 μ W/cm ²	<input type="checkbox"/> AMBIENT < 2 fc
PENETRANT ZL67	MINIMUM DWELL TIME	45	MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT	<input type="checkbox"/> TROUBLELIGHT
PENETRANT REMOVER H2O	MINIMUM DRY TIME	>10	MIN.	OTHER	<input type="checkbox"/> OUTPUT > 100 fc @ SURFACE	
DEVELOPER SKDS2	MINIMUM DWELL TIME	10	MIN.	LIGHT METER S/N	CAL FEB 12 08	
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY		CAL DUE DATE	

SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/20°F	<input type="checkbox"/> -4°C/20°F TO 10°C/50°F	<input type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	
RESULTS-	<input type="checkbox"/> METRIC <input checked="" type="checkbox"/> IMPERIAL				

FLUORESCENT LIQUID PENETRANT INSPECTION
 CARRIED OUT ON 100% EXTERNAL
 SURFACE ON:
 212/205 HIGH AFT X TUBE JOB# 37055, 37057.
m.m.
 206L AFT X TUBE JOB# 36977 (36979)

RESULTS: NO INDICATION OF DEFECTS.
 ITEMS ACCEPTABLE TO STANDARD

Scope of Services
 The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner operator and the owner operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
 In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar location. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

CLIENT REPRESENTATIVE	<i>Hewett</i>	PRINT	<i>Terry</i>	SIGNATURE	DTR # E21524
TECHNICIAN (SIGNATURE):				REPORT	
NAME (PRINT):	JASON HEWETT	1 ST TECHNICIAN	2 ND TECHNICIAN	REVIEWED BY:	NAME INITIALS
	CGSB LEVEL 2	SNT LEVEL	CGSB LEVEL	SNT LEVEL	
	CGSB REG. NO 6156		CGSB REG. NO		

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY